

Date: Thursday, 27/11/2008 2:37:38 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW
<b>Job Number</b> : 43829	
<b>Estimate Number</b> : 12701	
<b>P.O. Number</b> :	<b>Part Number</b> : D119647011
<b>This Issue</b> : 27/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3034 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 41326	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/12/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.27</u>	
<b>Comment</b> :	
Est Rev:A New Issue 07-02-02 JLM	
Est Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC	
Est Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC	
Est Rev:D New Manufacturing Method 08-11-17 JLM	
Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JUD 08/12/03*



**Comment:** Photocopy bluefile & type labels per PPP D119-647-011 CHG 002 *08/10/21*

2.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING  
Program Batch Number

*08-11-28*

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 4.2284 sf(s)/Unit Total : 8.4567 sf(s)  
UHMW 1" Black 28.75" X19.50"  
Batch: *109186* *8-12-2*

*(4)*

4.0	WATER JET	FLOW WATER JET
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*8-12-2*



**Comment:** FLOW WATER JET  
CUT BLANK AS PER FILE D3034-1\_BLANK

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA148 Rev: *AA* & Dwg D3034 Rev: *A*

*J.L. 09/01/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 27/11/2008 2:37:38 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 43829

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr per dwg D3034

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/01/15

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 0.4809 f(s)/Unit Total: 0.9618 f(s) *SEPINS*

Rubber Cushion (6x 5.5") = 33" x 2

Batch: 42737

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Radius Block

Batch: 42099

11.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Batch: 42408

12.0

D2947

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Clamp

Batch: 36826 SX

*7/01/21 (2)*

*Mo 902 7X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 27/11/2008 2:37:38 PM  
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## Process Sheet

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Drawing Name: BEARPAW

Job Number: 43829

Part Number: D119647011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN415A	Bolt
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

Batch: M109148

14.0	AN960JD416	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Batch: M109249

15.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Batch: M109282

16.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-647-011

Location: 22

PPP Rev: B

18.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>D3034DART AEROSPACE LTD</b>		<b>Work Order:</b> 43829
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3034-1
<b>Inspection Dwg:</b> D3034	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	11.75	+/-0.030	11.751	✓			
B	3.40	+/-0.030	3.400	✓			
C	19.00	+/-0.030	19.00	✓			
D	0.375	+/-0.010	.370	✓			
E	0.950	+0.030/-0.010	.952	✓			
F	0.06 x 45°	+0.030/-0.010	.055x45°	✓			
G	0.25 x 45°	+/-0.030	.265x45°	✓			
H	R0.25	+/-0.030	.25	✓			
I	0.630	+/-0.030	.625	✓			
J	0.250	+/-0.010	.253	✓			
K	4.50	+/-0.030	4.500	✓			
L	0.20	+/-0.030	.191	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.925	✓			
O	0.30	+0.030/-0.000	.310	✓			
P	28.25	+/-0.030	28.25	✓			
Q	0.37	+/-0.030	.375	✓			
R	4.750	+/-0.030	4.748	✓			
S	9.750	+/-0.010	9.750	✓			
T	11.000	+/-0.010	11.000	✓			
U	8.66	+/-0.030	8.670	✓			
V	5.000	+/-0.010	5.000	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/01/15	<b>Date:</b> 09/01/16	<b>Date:</b> N/A

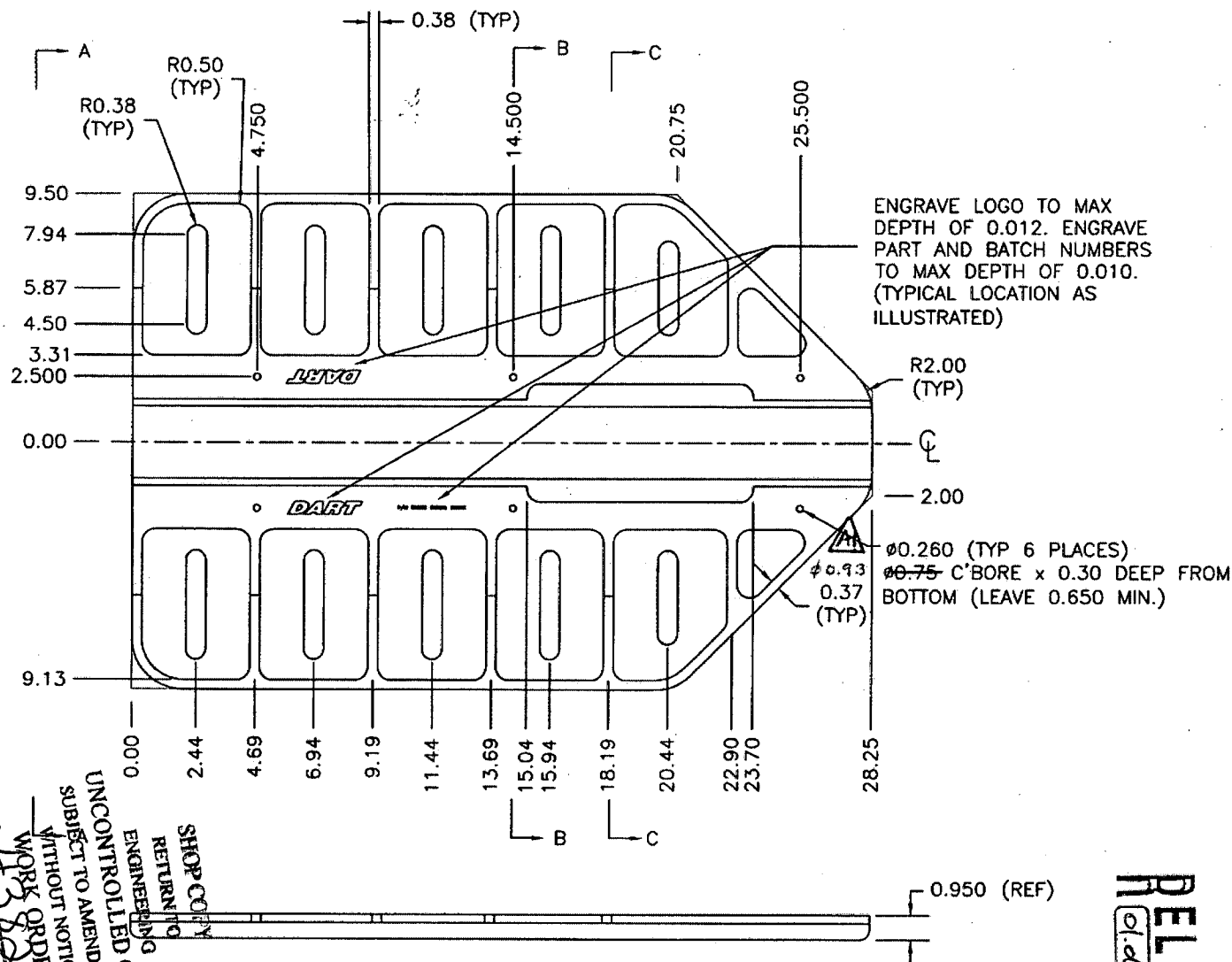
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D119-647-011	KJ/RF	✓



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. A
RT	CP	DRAWING NO. D3034	SHEET 1 OF 2	1:6
CHECKED	APPROVED	TITLE BEARPAW	SCALE	
DATE 01.06.21				
A	01.06.21	NEW ISSUE		

RELEASED  
01.06.26

A1 03.01.06 0.93 WAS 0.75



NO. 43803  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
RETURN TO

D3034-1

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689

1.00 THICK (MACHINE TO 0.950)

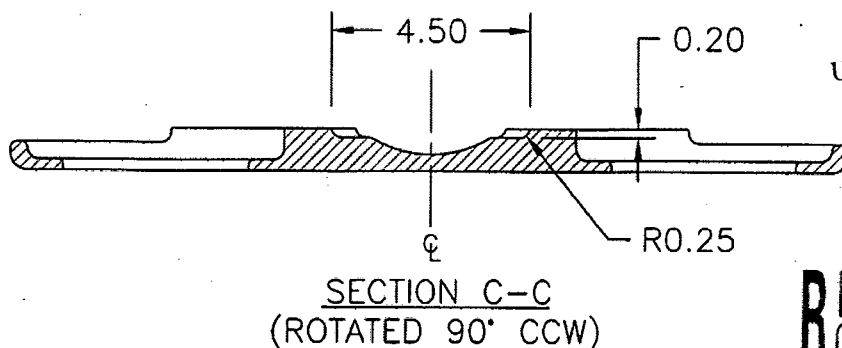
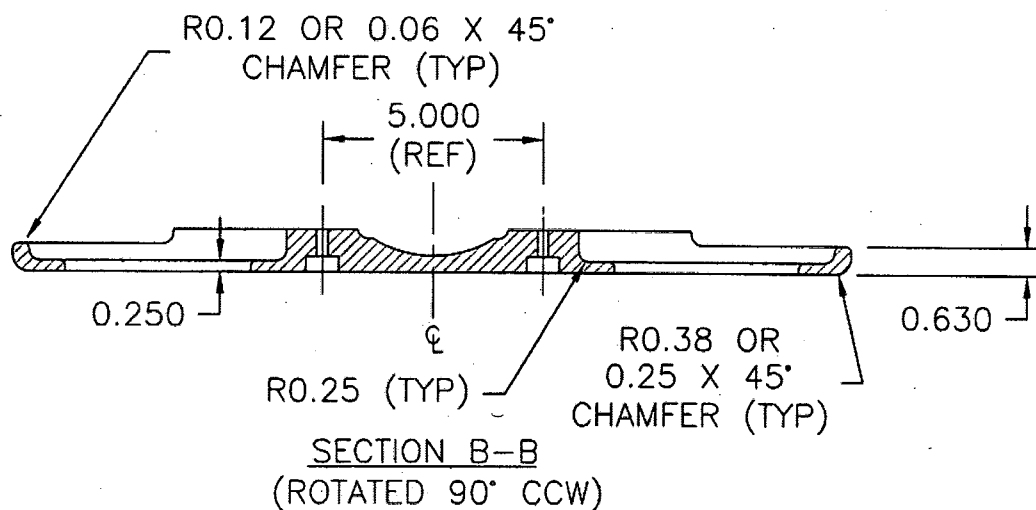
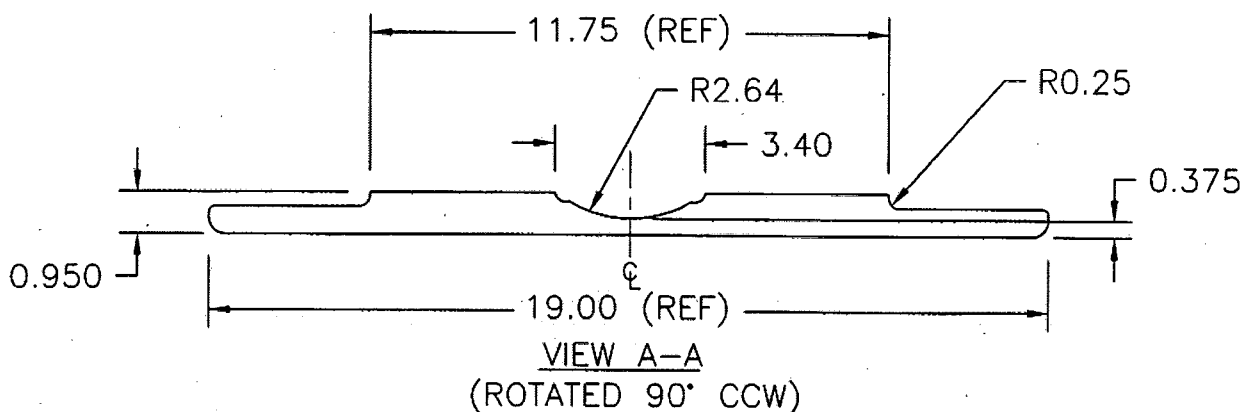
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DESIGN R	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3034	REV. A SHEET 2 OF 2
DATE 01.06.21		TITLE BEARPAW	SCALE 1:4



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RELEASED  
01.06.21

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